

Date: Wednesday, 6/7/2006 11:10:37 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: DOOR ASSEMBLY	
Job Number	: 27445		Part Number	: D41269402	
Estimate Number	: 12356		Drawing Number	: D412-694	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 6/7/2006 S.O. No. : N/A		Drawing Revision	: C1	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 6/16/2006 Qty: 1 Um: Each	
Previous Run	: 27340B				
Written By	:				
Checked & Approved By	:				
Comment	: Est Rev: A 05.12.09 New Issue KJ/RF Est. Rev B New dwg rev. ecn781 06.04.18 EC				

See w/024660
D412-694-02-04

Additional Product

PO 2008860

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL
Comment: DOCUMENT CONTROL Issue red decal labels for D412-694-02. CHG005		
2.0	COMPOSITE ASSY	COMPOSITE ASSEMBLY
Comment: COMPOSITE ASSEMBLY D412-694-02 Drill Process 1- D412-694-02 Drill Process Drill (7) holes using Ø(#40) drill. Drill (3) holes top/bottom Ø(#40) for insert (do not pass thru) using B30-23000-02 as per Dwg D412-694 page 4 (view P). 2- Open (1) hole to 11/16" (0.688) for the handle using unibit. Transfer (4) Ø(#30) holes from D3151-041 to the door and c'sink from far side for the rivet. Transfer (2) holes Ø(3/16") for MS24694-C5 screw as per Dwg D412-694 page 4 (view P). Note: D3151-041 orientation in the door. 3- Open (3) holes Ø(#19) or (0.166) top/bottom of the door and c'sink Ø0.300 x 100° from the far side and D3155-041/-042 bracket assembly as per Dwg D412-694 page 4 (view P). 4- Drill Ø(#30) holes using drill Jig D3144-T7 for the doublers. Drill (2) holes in two places Ø 3/16" (0.188) for the slot opening. Router slot using D3144-T8/-T9 as per Dwg D412-694 page 2. Note: The (12) holes for the (6) nut plates cannot be less than 0.290" from inside edge. 5- Use unibit to open (3) holes to Ø37/64" (0.578) at top/bottom insert for D3163-042 cover assembly as per Dwg D412-694 page 4 (view P). Drill Ø(#30) outer door handle as shown in view Z-Z page 2. Open holes to Ø0.257. 6- Drill Pilot holes Ø(#1/8") for rollers using drill Jig DT8703-7. Use unibit to open holes to Ø 37/64" (0.578) for inserts as per Dwg D412-694 page 2, page 6 (view K, L, M, Q). 7- Drill Pilot holes Ø(#1/8") for rollers using drill Jig DT8703-8. Use unibit to open holes to Ø 37/64" (0.578)		

W/O:		WORK ORDER CHANGES					
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Description :

for inserts as per Dwg D412-694 page 2, page 6 (view H, J).

✓ 8- Drill (27) pilot holes Ø(#30) using drill Jig DT8703-9RH for D3126 brackets as per Dwg D412-694 page 2 (view G-G). Use unibit to open holes Ø37/64" (0.578) for inserts.

✓ 9- Drill (2) Pilot holes Ø(#30) by transfer from D3152-042 bracket. Use unibit to open holes to Ø37/64" (0.578) for inserts as per Dwg D412-694 page 6 (view Q).

✓ 10- Drill (12) Ø(#30) holes from the edge of the door to opposite side for D3162-041 bracket using a long drill and keep drill perpendicular. Ensure (4) holes used from the center of the hole to top and bottom edge of the thick section of D3163-041 cover assembly. Compare hole depth with rivet in the foam as per Dwg D412-694 page 4 (view P) and (view R-R-S-S). Drill (8) Ø(#30) holes from the edge of the door using a long drill and keep drill perpendicular. About the (4) last holes around the small square of the cover, take the measurement 0.250" from each corner of the D3163-042 cover.

ml 06/09/15 ✓

3.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ml 06.09.15

4.0 8000528

Insert



Comment: Qty.: 55.0000 Each(s)/Unit Total : 55.0000 Each(s)

Insert ml 15493

Batch

A/R Hysol EA934NA

M 100775

Expiry Date:

25 April 2007

✓

5.0 COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

1- Install inserts as per Dwg D412-694 page 2 (view G-G); page 6 (view H, J, L, M, Q).
2- Sand flush excess Hysol around the insert on both doors.

ml 06/09/20 ✓

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect that inserts are flush with the surface.

ml 06.09.20 (1)

7.0 SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

ml 06/09/20

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Description :

8.0 QC14 Inspect Spray Paint



Comment: Inspect Spray Paint

6/06/20

9.0 D31105 Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Handle

B 25502

10.0 D31151 Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket

Batch

B 24626

11.0 D31167 Seal ZX2054



Comment: Qty.: 5.6666 f(s)/Unit Total : 5.6666 f(s)

Seal ZX2054

Batch

B 27239

12.0 D31169 Seal ZX1267



Comment: Qty.: 6.4166 f(s)/Unit Total : 6.4166 f(s)

Seal ZX1267

Batch

B 17463

13.0 D3121041 Bracket Assembly



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Bracket Assembly

Batch

B 23700

14.0 D3121044 Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket Assembly

Batch

B 24678

W/O:		WORK ORDER CHANGES							
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Job Number:



Seq. #: Machine Or Operation:

Description :

15.0 D31221 Lever



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Lever

Batch

25539

✓

16.0 D31231 Cam



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Cam

Batch

M10536-17

✓

17.0 D31241 Hook



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Hook

Batch

M10536-17

✓

18.0 D31242 Hook



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Hook

Batch

M10536-17

✓

19.0 D31261 Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket

Batch

25492

✓

20.0 D31263 Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket

Batch

18657

✓

21.0 D31265 Bracket



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bracket

Batch

10536-17

✓

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Seq. #: Machine Or Operation:

Description :

22.0 D31271

Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Spacer

Batch

N / 4

✓

23.0 D3132042

Rod Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rod Weldment

Batch

10536-17

✓

24.0 D3133041

Rod Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rod Weldment

Batch

10536-17

✓

25.0 D3135041

Handle Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Handle Weldment

Batch

B24683

✓

26.0 D3137045

BRACKET ASSEMBLY



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BRACKET ASSEMBLY

Batch

B27339

✓

27.0 D31382

Cover



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cover

Batch

B23121 B

P10

✓

28.0 D31391

Guard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Guard

Batch

B18863

✓

W/O:		WORK ORDER CHANGES							
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01/09/18	27	Lost cover Re-put in inventory?? when moving parts ??	BS 07/09	Re-pick one D3138-2 in stock 01/09/18 <u>M24341</u>	ML 07/09/18	BS 07/10/18	BS 07/10/18	BS 07/10/18	BS 07/10/18	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 01/10/18
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Job Number:



Seq. #: Machine Or Operation:

Description :

29.0 D31394 Guard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Guard

Batch

B24700

30.0 D314006 Door Kit



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Door Kit

Batch

B27445

18437

31.0 D31411 Spring #204-032-734-001



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spring #204-032-734-001

Batch

B27236-1

32.0 D314413 Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Doubler

Batch

21911

33.0 D3144111 Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Doubler

Batch

B27380

34.0 D3144115 Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Doubler

Batch

B22021

35.0 D3144123 Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Doubler

Batch

B22025

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Description :

36.0 D31481 Clevis



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Clevis

Batch 110536-17

✓

37.0 D3151041 Doubler Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Doubler Assembly

Batch B24685

✓

38.0 D3152042 Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket Assembly

Batch B18867

u

u

39.0 D3155041 Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket Assembly

Batch B27178

PTO

40.0 D3155042 Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket Assembly

Batch B24343

✓

41.0 D31561 Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bracket

Batch B24706

✓

42.0 D3162041 Bracket Assembly



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

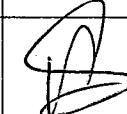
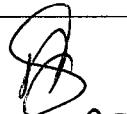
Bracket Assembly

① B24709

Batch ⑨ B24688

✓

W/O:		WORK ORDER CHANGES							
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06/09/05	39	Make a deep groove on D3155-041 with Cam D3123-1 D3123-1 when try to fix	 QWYD	Scrap one D3155-041 replace by new one in stock.	2nd 06/09/05	 06/09/05	 06/09/05	 06/09/05

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/10/05
 NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

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Drawing Name: DOOR ASSEMBLY

Job Number: 27445

Part Number: D41269402

Job Number:



Seq. #: Machine Or Operation:

Description :

43.0 D3162043 BRACKET ASSEMBLY



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket Assembly

Batch

B27348



44.0 D3162044 BRACKET ASSEMBLY



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket Assembly

Batch

B24977



45.0 D3163042 Cover Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cover Assembly

Batch

27484



46.0 D3183042 Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket Assembly

Batch

B27604



47.0 D32031 Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Handle

Batch

B24956A



48.0 D33081 Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Doubler

Batch

B21912



49.0 AN52510R6 Screw



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Screw

Batch

M15943



W/O:		WORK ORDER CHANGES							
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Job Number:



Seq. #: Machine Or Operation:

Description :

50.0 AN52510R7 Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Screw

Batch

15387(3)

101203(6)

✓

51.0 AN960JD8 Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Washer

Batch

M11989

✓

52.0 AN960JD10L Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Washer

Batch

M16612

✓

53.0 AN960JD10LL Washer



Comment: Qty.: 15.0000 Each(s)/Unit Total : 15.0000 Each(s)

Washer

Batch

11763

✓

54.0 AN960JD416L Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Washer

Batch

3154

✓

55.0 BSP45 Commercial Rivet



Comment: Qty.: 79.0000 Each(s)/Unit Total : 79.0000 Each(s)

Commercial Rivet

Batch

M11821

✓

56.0 BSP46 Commercial rivet



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Commercial rivet

Batch

M19098

✓

W/O:		WORK ORDER CHANGES							
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Job Number:



Seq. #: Machine Or Operation:

Description :

57.0 M7885243 Rivet



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Rivet

Batch

M19099

✓

58.0 MS203922C9 Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pin

Batch

M11784

✓

59.0 MS203922C17 Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pin

Batch

M11735

✓

60.0 MS203923C21 Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pin

Batch

M11765

✓

61.0 MS20426AD33 Rivet



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Rivet

Batch

M520126 M1563

✓

62.0 MS20426AD48 Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) For this step I used 46 Rivet

Rivet

Batch

M32456 M3566
Do not change w/o

✓

63.0 MS20426AD47 Rivet



PTO

Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Rivet

Batch

M12655

✓

W/O:		WORK ORDER CHANGES					
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06/09/19	63	<u>Permanent change (See $\Delta C1$ on View R-R)</u> <u>Now using only 4 nuts ms30426 A04-7 AND</u> <u>12 nuts M7885-3-4-4 M15659</u>	E ml sc	06/09/19		<i>AB</i> 06/09/19	<i>AB</i> 06/10/19

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Seq. #: Machine Or Operation:

Description :

64.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch

11991



65.0

MS21042L08

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Nut

Batch

15003



66.0

MS21072L3

Nutplate



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nutplate

Batch

18728



67.0

MS24665151

Cotter Pin



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Cotter Pin

Batch

m17566



68.0

MS24693S271

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

Batch

m14478



69.0

MS24694C5

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

Batch

m11755



70.0

MS24694S5

Screw



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Screw

Batch

m11735

m18949



W/O:		WORK ORDER CHANGES							
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Job Number:



Seq. #: Machine Or Operation:

Description :

71.0 MS24694S50

Screw



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Screw

Batch M14206

✓

72.0 MS24694S98

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

Batch M16255

✓

73.0 MS27039105

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

Batch M3501

✓

74.0 MS27039106

Screw



P70

Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Screw

Batch M11754

P70

75.0 MS27039108

Screw



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)

Screw

Batch 13356

P70

76.0 MS35275233

Screw



✓

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

Batch M11822

✓

77.0 MS35649264

Nut



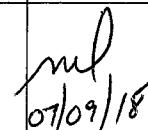
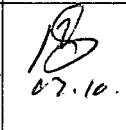
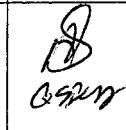
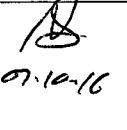
✓

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch M11822

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
07/09/18	74 and 75	Lost these Screws. Re-put in inventory 777 when arriving parts...	 DSW	Re-Pick these parts 13x MS 27039-108 <u>m104215</u> 14x MS 27039-106 <u>m11954</u>	 ml 07/09/18	 07.10.18	 DSW	 07.10.18
								

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/10/18
 NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

Date: Wednesday, 6/7/2006 11:10:38 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 27445

Part Number: D41269402

Job Number:



Seq. #: Machine Or Operation:

Description :

78.0 MS356503252 Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch

M11735



79.0 MS518597 Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch

11822



80.0 NAS43DD310 Spacer



PTO

Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

Spacer

Batch

M19185

PTO

81.0 NAS43DD314 Spacer



PTO

Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Spacer

Batch

11785

82.0 COMPOSITE ASSY COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

D412-694-02 Assembly Process

✓ 1- Install D3162-041 as per Dwg D412-694 page 4 (view R-R/S-S) and D3156-1 bracket as per (view T-T/U-U). Open holes to #30 (0.128) for rivet and alodine the open holes.

Note: Start installation window side. Wait to fix D3162-043/044.

✓ 2- Install D3151-041 Doubler as per Dwg D412-694 page 4 (view P).

✓ 3- Connect D3132-042 Rod Weldment with D3122-1 Lever and D3133-042 Rod Weldment as per Dwg D412-694 page 4 (view P).

✓ 4- Assemble D3123-1 Cam with D3124-1/-2 Hook with D3155-041/-042 Bracket Assembly as per Dwg D412-694 page 4 (view P).

✓ 5- Install D3203-1 handle with D3308-1 doubler as per Dwg D412-694 page 2 (view Z-Z).

✓ 6- Install D3155-041/-042 Bracket Assembly and D3110-5 Handle as per Dwg D412-694 page 4 (view P) and

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
07/09/18	80 and 81	Lost these spaces Re-put in inventory When moving parts/???	BS Wesun	✓ Re-pick these parts 7x NAS 43 DD3/0 M19347 6x NAS 43 DD3/14 M19347	ML 07/09/18	BS 07-10-18	BS 0297012	BS 07-10-18

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes DQA: Date: 07/10/18

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Wednesday, 6/7/2006 11:10:38 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 27445

Part Number: D41269402

Job Number:



Seq. #: Machine Or Operation:

Description :

page 2. Adjust rod weldment until everything works properly and looks in place.

83.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Feb-04-05

84.0

COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

✓ D412-694-02 Assembly Process (Continued)

1- Install D3116-7-0680 Seal and doublers. Transfer slot opening in the seal as per Dwg D412-694 page 2 (view V-V and N).

Note: If this is the D412-694-013, wait until the VIP trim is fixed on the door.

✓ 2- Install D3110-5 Handle Assembly in the D3163-042 Cover Assembly. Ensure Handle works freely. Ensure D3163-042 cover assembly is aligned with the door edge on both sides and D3110-5 Handle works properly.

✓ 3- Transfer the holes to the cover with the hole finder. EXCEPTION: the (4) holes around the handle. Install the bracket with the holes from the small square of the cover ($\varnothing 0.250"$)

✓ 4- Open 15/64" (0.234) holes to D3163-042 cover assembly and D3135-041 handle weldment. Transfer D3139-1/4 guard holes in cover assembly and drill holes for nutplate. Deburr and touch up holes with alodine as per Dwg D412-694 page 2.

✓ 5- Install MS21072-L3 Nutplate and Guard as per Dwg D412-694 page 2.

✓ 6- Transfer (#30) holes from D3144-13 doubler to seal and door. Ensure D3116-9-0770 is properly aligned as per Dwg D412-694 page 2 (section NN-NN). Apply 732 RTV Clear (A/R) in the hole prior to installing rivet and then in the rivet head after installation.

→ m16368
17 Feb 2007 exp.

7- Install D3126 Brackets and D3138-2 Cover as per Dwg D412-694 page 2 (view G-G and NN-NN).

✓ 8- Install and assemble brackets as per Dwg D412-694 page 2 and 5 (view H, J, L, M and Q).

Mar 10/05

85.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

See Sheet attached

86.0

COMPOSITE ASSY

COMPOSITE ASSEMBLY



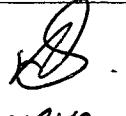
Comment: COMPOSITE ASSEMBLY

1- Finish installing D3163-042 in the door.

2- Install red decal before closing cover.

Mar 07/10/16 X1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
07/10/10	85	Corner Upper Aft is to curved. Have to take out 2".300 ← 5".850 ↑ and .300 deep on corner	 07/10/10	See attached sheet	 07/10/10	 07/10/10	 07/10/10	 07/10/10

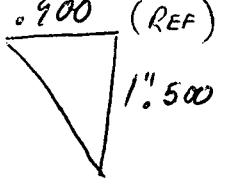
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/10/10

NOTE: Date & initial all entries

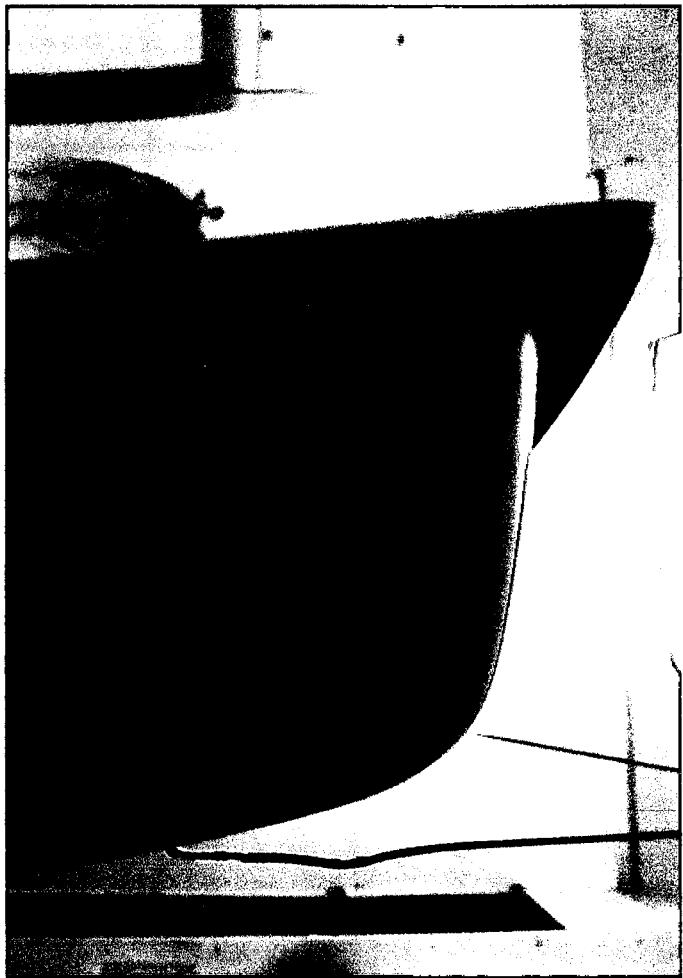
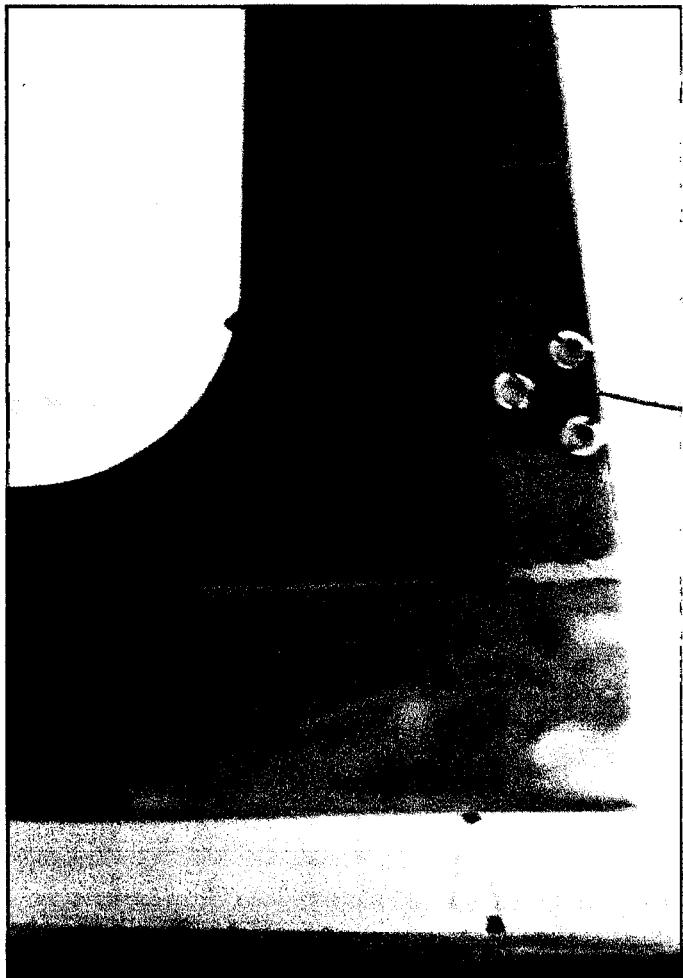
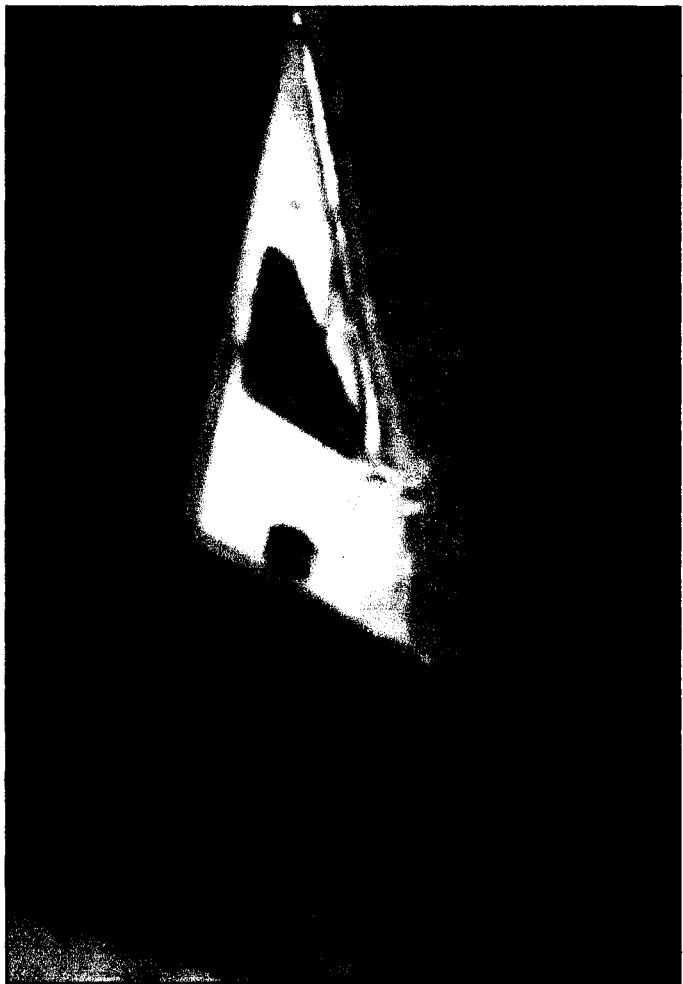
QA: N/C Closed: _____ Date: _____

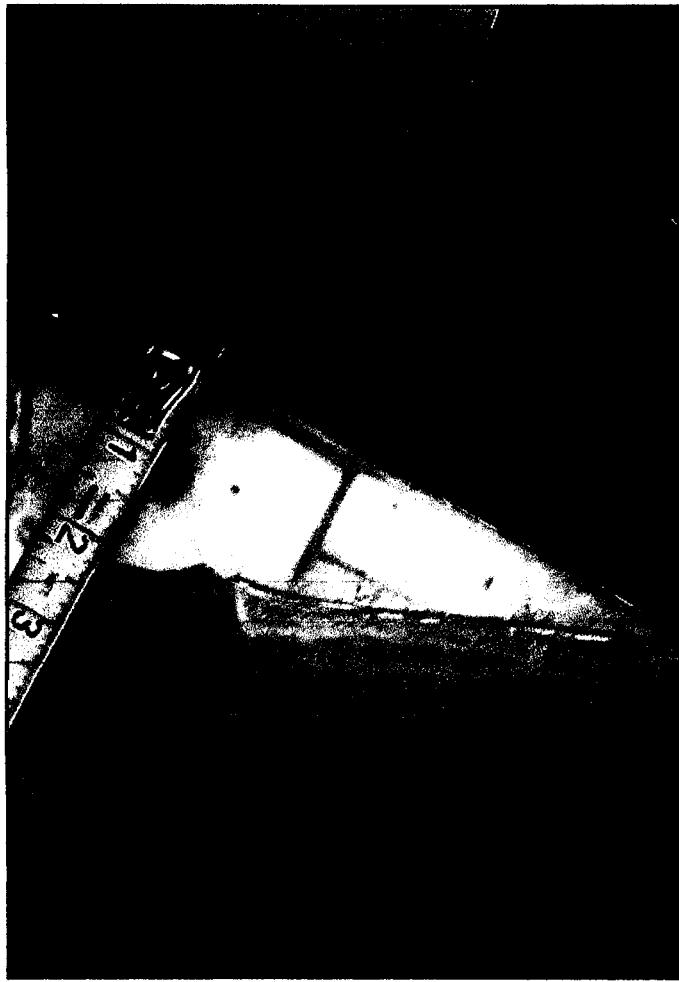
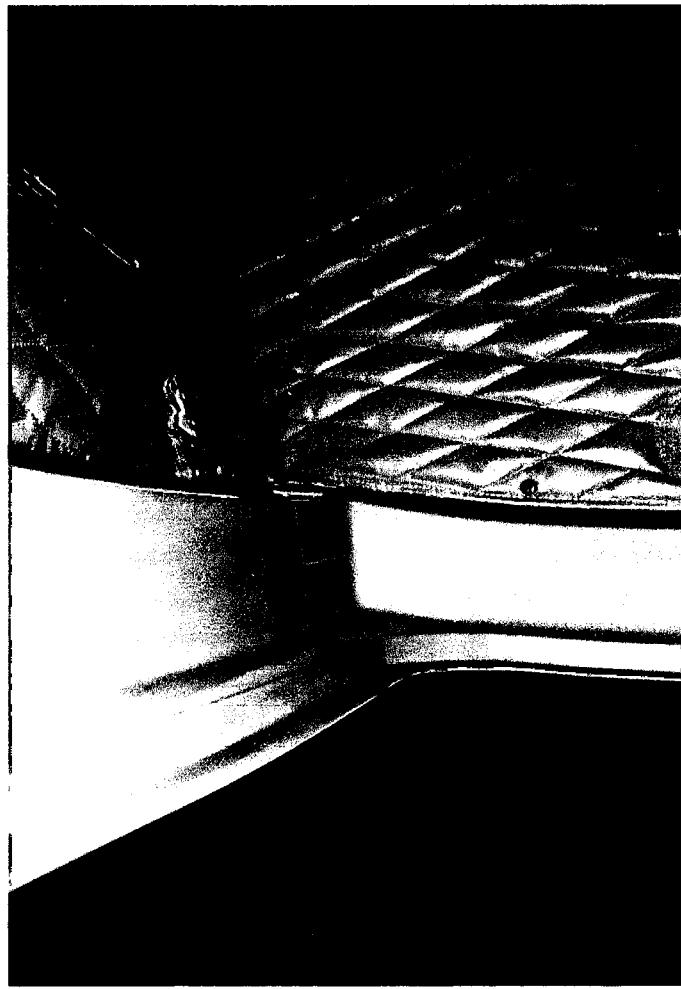
W/O 27445

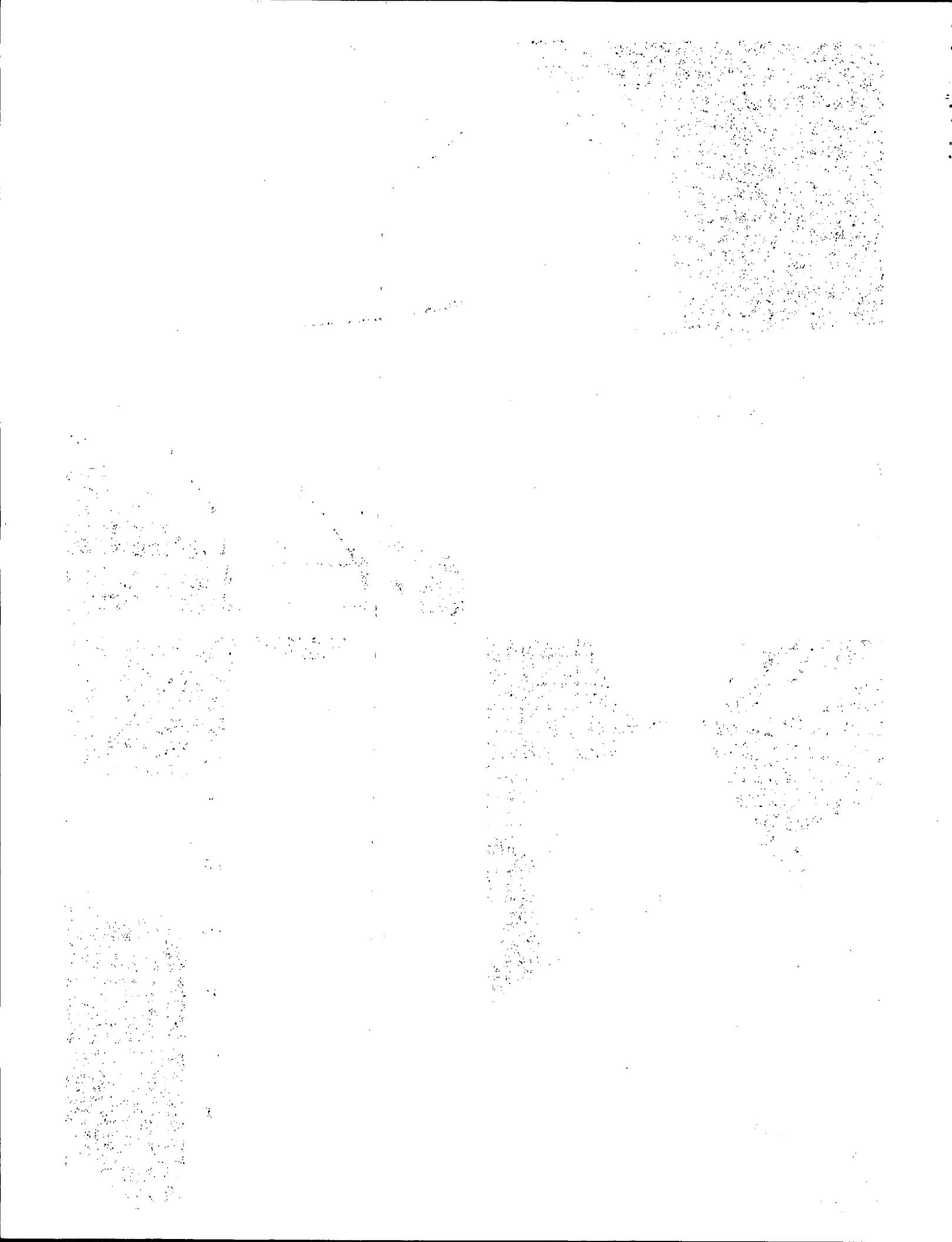
Step 85. on door D 412-694-02

- Buffed the aft Upper Corner
- Have to cut the doubler D 3140-241 for having the good shape.
- The joint was cover by new small hand made doubler about 
- Use 2024-T3 .020 as doubler D 3140-241 3# M11622
- Rough Scrag - Alodine - Press foam of the door for fit the New piece
- Hypol EA 9309 M103866 A/R - Exp. March 19/2008
- milled fiber M100859 A/R
- 9oz Eglass (2 layers) M104548 A/R
- let dry 24 hours and Re prime where Need it after sanding.

M107/10/12







Date: Wednesday, 6/7/2006 11:10:38 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 27445

Part Number: D41269402

Job Number:



Seq. #: Machine Or Operation:

Description :

87.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Install door on mock up helicopter to insure proper fit and function.

1007-10-16

88.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

1007/10/17 ①

89.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

①
1007/10/17 ①

Job Completion



1007-10-16

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector		
			Initial Design Mgr	Action Description Design Mgr	Sign & Date					

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____